

# Work Order ID 44601

June 26, 2009 10:51:25 AM

Page 1

Item ID: D350-636-011

Revision ID: F

Item Name: Skidtube LH

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end 2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863. 3- Mark fwd end for cutting using Drill Jig

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*D3701-1 x4*  
*Need to delete w/o - to create*

Accept

Cust Item ID:

Customer:

*was previous No good*

*u*

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Item ID: D350-636-011

Accept



Setup Start



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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.1 2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.1 3- Open float hole to 0.500" (4 per side); 4-Chamfer holes of Det

170

0.00



QC10- Inspect visual per QS1004- ground welds

QC

Memo

0.00

Quality Control

180

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

# Work Order ID 44601

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Item ID: D350-636-011

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: \_\_\_\_\_ OVEN TEMPERATURE:  
FINISH TIME: \_\_\_\_\_

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

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Accept



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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects! 2-Spray inside of tube with "LPS-3"  
batch: 13-Install blade fitting D3488-041, wearshoes and ground  
handling hardware as per dwg D2750! SIKAFLEX  
2411 BATCH: EXP DATE: 14-assemble  
o'ring

240

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

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Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

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Item ID: D350-636-011

Accept



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Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

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[illegible]

(b) (7)(C), (b) (7)(D)

**Start Date:** 15/07/2009

**Required Date:** 03/08/2009

**Start Qty: 1.00**

**Required Qty: 1.00**

[illegible]



# Picklist Print

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Work Order ID: 44601

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



















Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A 		Purchased	No			230	Each	0.0000	4.0000 			
BOLT AN8C35A 		Purchased	No			230	Each	0.0000	1.0000 			
BOLT AN960C10L 		Purchased	No			230	Each	0.0000	38.0000 			
washer AN960C816L 		Purchased	No			230	Each	0.0000	1.0000 			
WASHER D2745RevB 		Manufactured	No			230	Each	0.0000	8.0000 			
Bushing D3488-041RevB 		Manufactured	No			230	Each	0.0000	1.0000 			
Blade Fitting Assembly, LH D3492-041RevC 		Manufactured	No			230	Each	0.0000	8.0000 			
Plug Assembly D3492-043RevC 		Manufactured	No			230	Each	0.0000	8.0000 			
Plug Assembly D3535-25RevB 		Manufactured	No			230	Each	0.0000	1.0000 			
Wearshoe												

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Shop Packet Print

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# Picklist Print

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Work Order ID: 44601

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



















Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA 		Manufactured	No			230	Each	0.0000	1.0000 			
Gasket D3537-1RevC 		Manufactured	No			230	Each	0.0000	3.0000 			
Wearpad D3631-1RevA 		Manufactured	No			230	Each	0.0000	8.0000 			
Washer D3791-1RevA 		Manufactured	No			230	Each	0.0000	1.0000 			
Wearplate D3793-1RevA 		Manufactured	No			230	Each	0.0000	1.0000 			
Wearshoe D3793-3RevA 		Manufactured	No			230	Each	0.0000	1.0000 			
Wearshoe D3794-1RevA 		Manufactured	No			230	Each	0.0000	1.0000 			
Gasket D3794-3RevA 		Manufactured	No			230	Each	0.0000	1.0000 			
Gasket MS21043-6 		Purchased	No			230	Each	0.0000	4.0000 			
NUT												

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# Picklist Print

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Work Order ID: 44601

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



















Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 		Purchased	No			230	Each	0.0000	1.0000 			
NUT NAS1611-010 		Purchased	No			230	Each	0.0000	1.0000 			
O-RING NAS1611-013 		Purchased	No			230	Each	0.0000	1.0000 			
O-RING AN8C21A 		Purchased	No			260	Each	0.0000	2.0000 			
BOLT AN960C816L 		Purchased	No			260	Each	0.0000	2.0000 			
WASHER D2741RevC 		Manufactured	No			260	Each	0.0000	1.0000 			
Blade, 350 Skidtube D3493-1RevA 		Manufactured	No			260	Each	0.0000	2.0000 			
Washer MS21083C8 		Purchased	No			260	Each	0.0000	2.0000 			
NUT NAS1515H3L 		Purchased	No			260	Each	0.0000	4.0000 			
WASHER												

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# Picklist Print

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Work Order ID: 44601

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:





Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L  WASHER		Purchased	No			260	Each	0.0000	2.0000 			

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Date: Wednesday, 10/07/09 10:53:27 AM  
 User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 44601	<b>Customer</b>	: Dart Helicopters Services LLC.
<b>Estimate Number</b>	: 13149	<b>DWG Name</b>	: FLOOR DOUBLER
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D37011
<b>Complete Date</b>	: / / : : AM	<b>DWG Number</b>	: D3701 PRELIM
		<b>Rev.</b>	: PRELIM

<b>DUE DATE</b>	<b>ORDERED</b>	<b>DELIVERED</b>
1/15/09	5	0

<b>1.0 M6061T6S080-6061-T6 .080 Sheet</b>	<b>INVENTORY ITEM</b>
---	-----------------------

DATE	EMPLOYEE	TYPE	Qty	COST	
1/13/09	BLEC01: Bleck, Henry	M6061T6S080	0.001	\$0.01	Lot # 110254 Qty. 0
<b>Subtotal:</b>		QTD: 0	CTD: 0	\$0.01	

<b>2.0 WATER JET</b>	<b>Internal Operation</b>
----------------------	---------------------------

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
1/13/09	BLEC01: Bleck, Henry	Run	5.000	0.24	\$4.04	0.24	9.82
<b>Subtotal:</b>		QTD: 5	CTD: 0	0.24	\$13.86		

		TIME	COST
	Machine Time:	0.24	\$9.82
	Labor:	0.24	\$4.04
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$0.01
	SUB-COMPONENT (SUB-JOB):		\$0.00
<b>Total:</b>			\$13.87

<b>COST PER UNIT:</b>	\$13.87
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# Work Order Summary

October 7, 2009 10:51:51 AM

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Criteria : Work Order ID: 44601 Item ID: D350-636-011RevF Product Family SKIDTUBES  
 Work Order Start Dates 7/15/09 to 7/15/09 11:59:59 PM Work Order Required Dates 8/03/09 to 8/03/09  
 11:59:59 PM

All References  
 Work Order Status Released

Work Order ID 44601 Required Qty 1.0000 Status Code Released  
 Item ID D350-636-011RevF Accepted Qty 0.0000 Scrap Qty 0.0000

Item Name Skidtube LH

Current Acct Value \$1,641.858

Sales Order ID

Start Date 7/15/09 Required Date 8/03/09

Completed Date

Standard \*\* Actual \*\* \*\* Acct. Value \*\* \*\* Variance \*\* \*\* Variance % \*\*

Direct Costs	Total	Each	Each	Each	Each
Material	\$0.020	\$0.000	\$383.472	\$383.472	100.00%
Labor	\$68.037	\$0.000	\$406.550	\$406.550	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$130.432	\$0.000	\$917.710	\$917.710	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>** Total **</b>	<b>\$198.489</b>	<b>\$0.000</b>	<b>\$1,707.732</b>	<b>\$1,707.732</b>	

Item ID/ Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
ZWIP	0.0000				
Opening WIP BALANCE MATERIAL COST			6/25/09	0.0100	\$0.010
			6/25/09	0.0100	\$0.010
			<b>Total Matl Amts:</b>		<b>\$0.020</b>

## Work Center

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
zwip												
	6/26/09											
N/A			0.00	0.00	4.04	4.04	1.00	\$0.000	\$4.040	\$9.696	\$0.000	\$13.73
N/A			0.00	0.00	0.11	0.11	1.00	\$0.000	\$0.114	\$0.000	\$0.000	\$0.11
<b>Total:</b>			0.00	0.00	4.15	4.15	2.00	\$0.000	\$4.154	\$9.696	\$0.000	\$13.85

## Work Center Skidtubes

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
MAHE01												
	8/26/09											
160			0.00	0.00	6.73	3.36	2.00	\$0.000	\$63.883	\$120.736	\$0.000	\$184.61
<b>Total:</b>			0.00	0.00	6.73	3.36	2.00	\$0.000	\$63.883	\$120.736	\$0.000	\$184.61

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Work Order Summary

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